

Work Order ID 60235

Tuesday, June 29, 2010 11:47:38 AM



Page 1

Item ID: D3536-35

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 6/29/2010 Start Qty: 16.00



Cust Item ID:

Required Date: 7/6/2010 Req'd Qty: 16.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3536	Rev A								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3536 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

mtl 10 . 07 . 15 (16)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

mtl 10 . 07 . 15 (16)

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8106215

(16)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60235

Tuesday, June 29, 2010 11:47:38 AM



Page 2

Item ID: D3536-35

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Setup Start



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Required Date: 7/6/2010 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>12</u>	0.00							
	Packaging								
	Memo	0.00							
	Packaging								
140	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Memo	0.00							
	Quality Control								

10-7-19 160

MF 10-7-19

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 29, 2010 11:47:42 AM

Page 1

Work Order ID: 60235

Parent Item: D3536-35

Parent Item Name: Gasket



Start Date: 6/29/2010

Required Date: 7/6/2010

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf.	364.8531	0.6197	10.43705			



NEOPRENE SHEET 0.063



Location

Loc Qty

Loc Code

MAT

259.6

114691

259.6

MAT052

105.2531

114176

105.2531

ml 10.07.15

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	60235
Description: Gasket		Part Number:	D3536-35
Inspection Dwg: D3536	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
23.25	+/-0.030	23.25	✓		M.T	
19.75	+/-0.030	19.75	✓		M.T	
17.75	+/-0.030	17.75	✓		M.T	
14.25	+/-0.030	14.25	✓		M.T	
9.50	+/-0.030	9.50	✓		M.T	
4.75	+/-0.030	4.743	✓		vern	
2.00	+/-0.030	2.00	✓		M.T	
6.00	+/-0.030	6.00	✓		M.T	
6.75	+/-0.030	6.75	✓		MT	
0.30	+/-0.030	0.309	✓		vern	
0.30	+/-0.030	0.309	✓		vern	
1.89	+/-0.030	1.88	✓		vern	
Ø0.19	+0.005/-0.001	0.191	✓		vern	
0.063	+/-0.010	0.065	✓		vern	

Measured by:	MM	Audited by:	S	Prototype Approval:	N/A
Date:	10-07-15	Date:	10/07/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

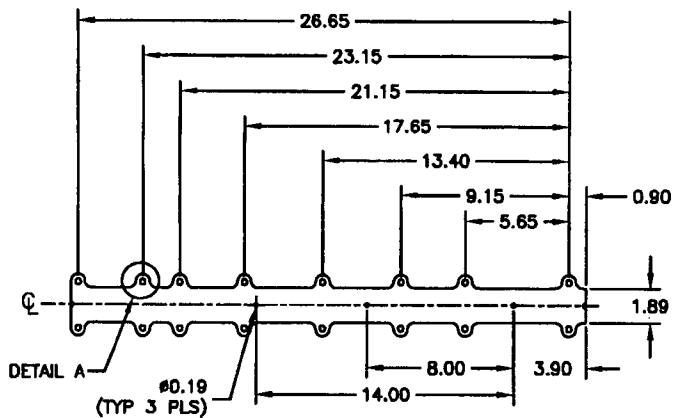
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CB	CB	PORT HADLOCK, WA	
CHECKED PH	APPROVED H	DRAWING NO. D3536	REV. A
DATE 06.10.25		TITLE GASKET	SHEET 1 OF 6
A	06.10.25	NEW ISSUE	SCALE 1:10

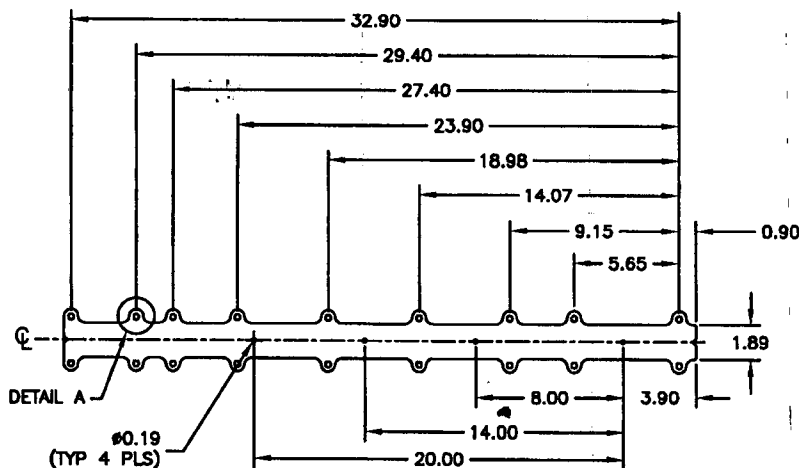
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04-2-12-1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60235
R/W-29



D3536-11 GASKET



D3536-13 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.083)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT \bar{C}
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

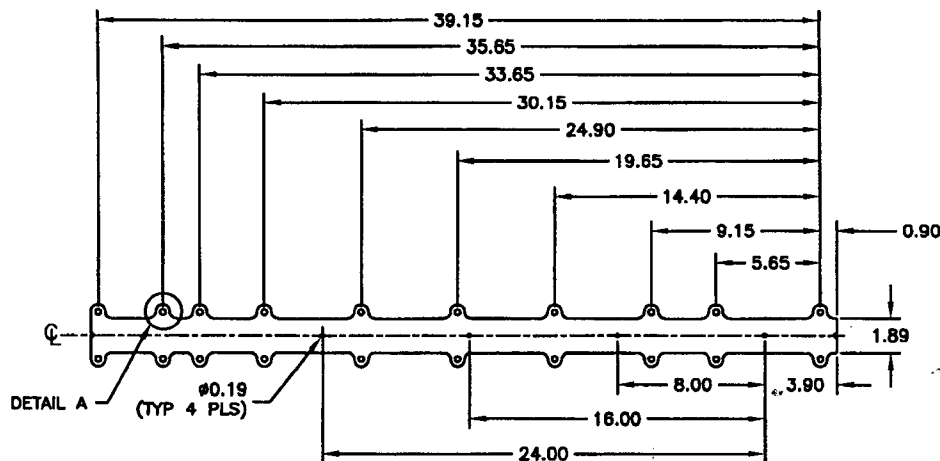
NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	CB	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
PH	PH	D3536
DATE	TITLE	REV. A
06.10.25	GASKET	SHEET 2 OF 6
		SCALE
		1:10

RELEASED
07.02.12

WLO 60235



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

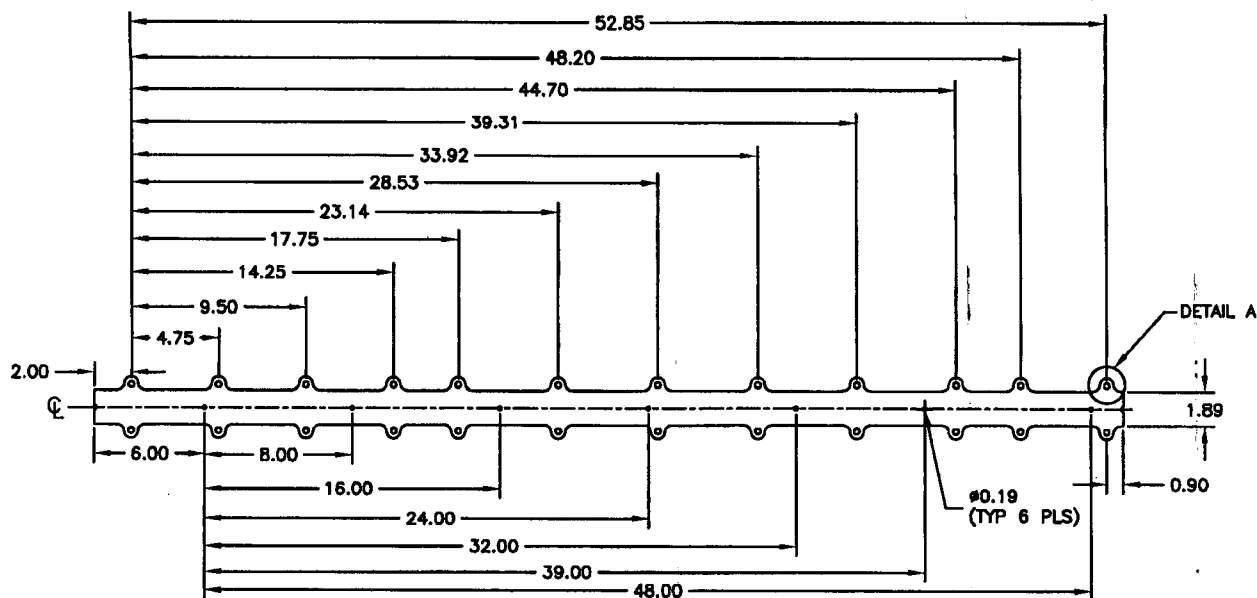
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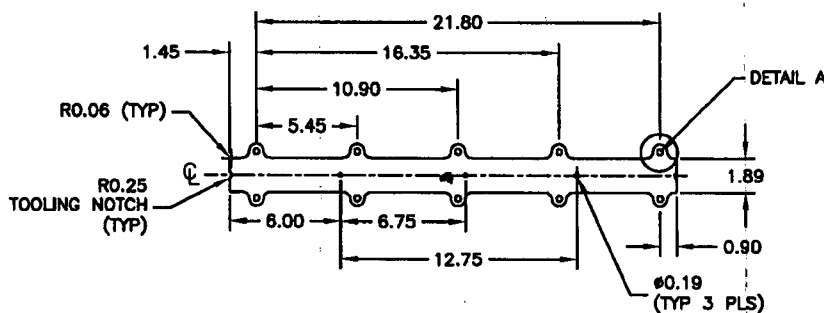
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DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	CB	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
PH	PH	D3536
DATE	TITLE	REV. A
06.10.25	GASKET	SHEET 3 OF 6
		SCALE
		1:10



D3536-23 GASKET

W/O 60235



D3536-25 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

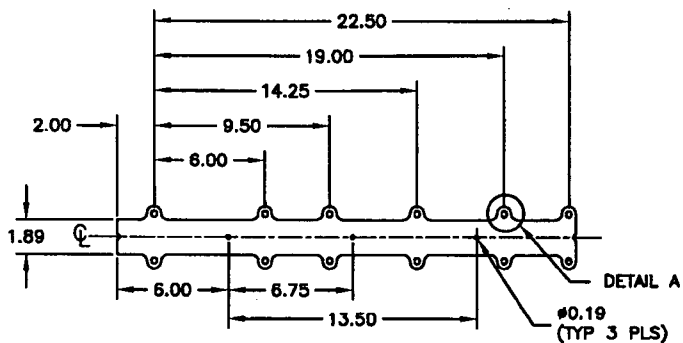
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NOTE: Date & initial all entries

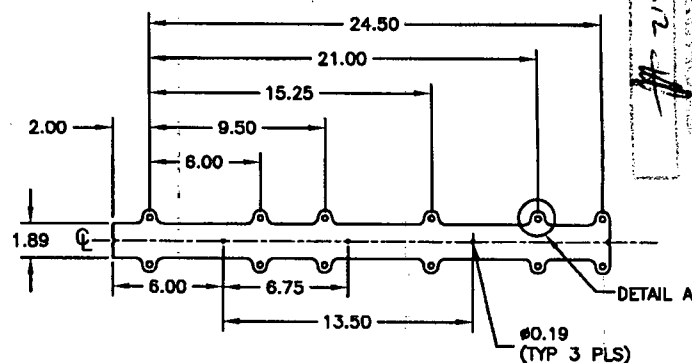
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DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
		GASKET		SHEET 4 OF 6
				SCALE 1:10

RELEASED
07.02.12

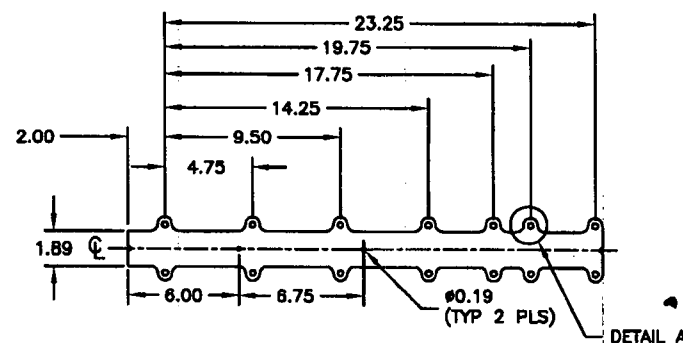


D3536-31 GASKET



D3536-33 GASKET

who 60235



D3536-35 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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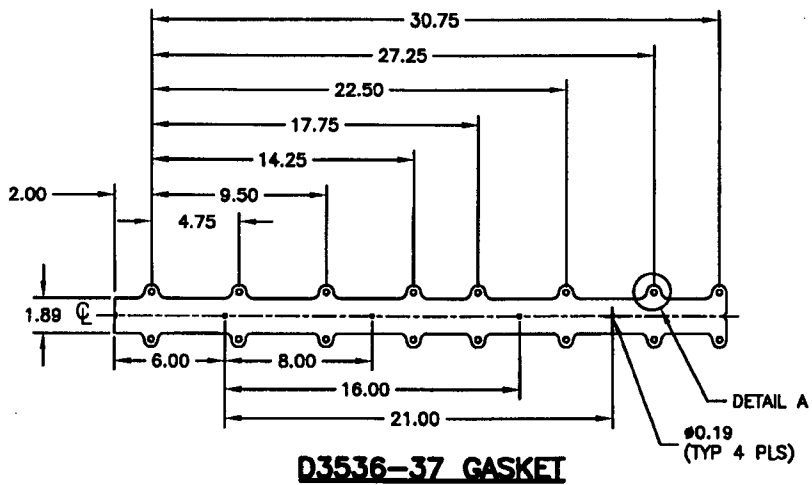
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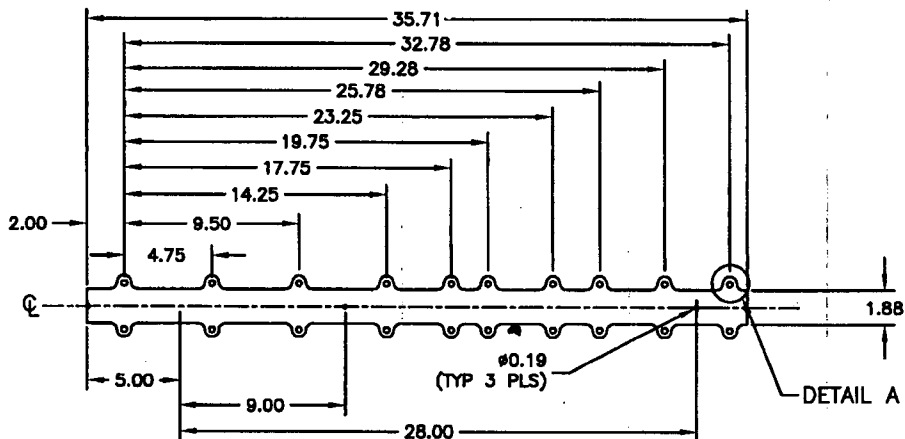
NOTE: Date & initial all entries

DART

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 5 OF 6
				SCALE 1:10



D3536-37 GASKET



D3536-39 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 80 DUROMETER (REF DART SPEC. M-NEO80-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

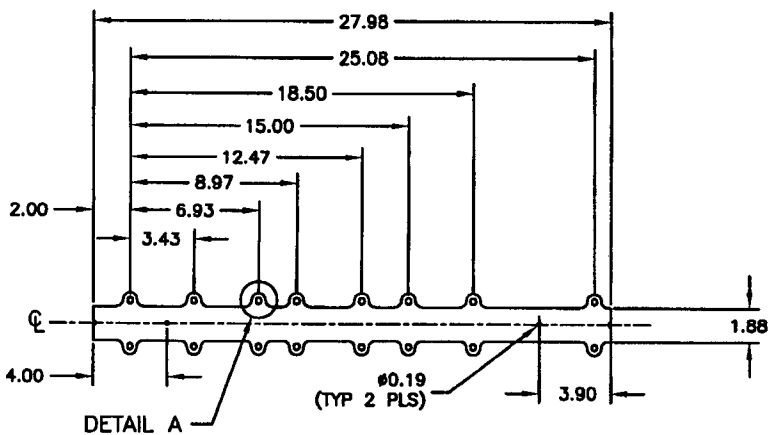
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
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DATE 06.10.25		TITLE GASKET	SCALE 1:10

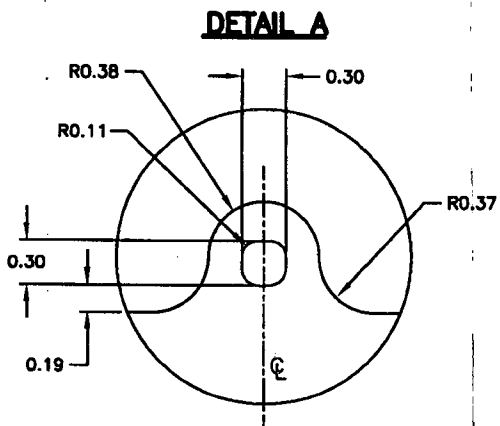
070212-4



D3536-41 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.083)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER



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